

# Work Order ID 66468

Tuesday, February 15, 2011 11:34:45 AM



Page 1

Item ID: D4292-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 2/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00



Customer:

Reference:

*Jan 11.02.15*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4292

C

100

0.00



BAND SAW

*ank 11/02/22*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to 6.250"

Batch: *M116930x3 M116867x1*

\*\*\*\*GRAIN DIRECTION MUST BE ALONG 4.00"\*\*\*\*\*

*4 0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

*ank 11/02/22*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB002

DWG REV: *AC*

FOLIO REV: *AA*

*4 0*

2- deburr rough edges

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

aml 11/02/22

4 0

Quality Control

121

0.00



Mill Conv

Memo

0.00

aml 11/02/22

4 0

Conventional Milling Machine

DRILL &amp; TAP FOR HELICOIL AS PER DWG

122

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

aml 11/02/22

4 0

Quality Control

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

JA

11/02/23

4

φ

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

4

φ

JL

11/02/23

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M15951

7:35

Powdercoat

Memo

320

0.00

Powder Coating

MASK THREADED HOLE

8:25.

4

BL

10-2-28.

**Work Order ID 66468**

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Page 4

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Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EM-k 11/02/28

(4X)

151

0.00



Small Fab

Memo

0.00

Small Fab

INSTAL HELICOIL

E 5/10/28

152

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.16228

(X)

**Work Order ID 66468**

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Page 5

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Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: Y81

0.00



Packaging

Memo

0.00

Packaging

11/03/01 Y81

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/01 Y81

11/03/01

# Picklist Print

Tuesday, February 15, 2011 11:34:42 AM

Page 1

Work Order ID: 66468

Parent Item: D4292-1

Parent Item Name: Fitting

Start Date: 2/16/2011

Required Date: 2/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV  
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M7075T73B4.000x4.00		Purchased	No			100	f	8.2168	0.52	2.189474			
---------------------	--	-----------	----	--	--	-----	---	--------	------	----------	--	--	--

0



7075-T73 Bar 4.0 x 4.0



## Location

## Loc Qty

## Loc Code

MAT

8.2168

116153

0.2578

116324

1

116764

6

< 116867 ~

0.959

Each

0.0000

4

MS21209F1-10

Purchased

No



HELI COIL

M116930 X 1.56'

amb 11/02/22

.52"



M116977



9511/02/28

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <del>65887</del> 66468
<b>Description:</b> FITTING		<b>Part Number:</b> D4212-1
<b>Inspection Dwg:</b> D4212 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.250	$\pm .030$ $\pm .010$	.256	—		Vern	ML-7
.125	$\pm .030$ $\pm .010$	.130	—		"	"
2.95	$\pm .030$	2.953	—		"	"
.275	$\pm .010$	.276	—		"	"
.800	$\pm .010$	.797	—		"	"
.825	$\pm .010$	.823	—		"	"
.375	$\pm .010$	.379	—		"	"
.88	$\pm .030$	.882	—		"	"
.663	$\pm .010$	.660	—		"	"
Ø.381	$\pm .000$ $\pm .001$	Ø.381	—		Micr	ML-01
Ø.320X100°	$\pm .010$ X 1/2°	Ø.330X100°	—		Vern	ML-7
1.125	$\pm .010$	1.125	—		"	"
1.063	$\pm .010$	1.058	—		"	"
5.99	$\pm .030$	5.990	—		"	"
5.86	$\pm .030$	5.864	—		"	"
2.84	$\pm .030$	2.840	—		"	"
.190	$\pm .030$	.191	—		"	"
1.200	$\pm .010$	1.200	—		"	"
3.44	$\pm .010$	3.440	—		"	"
2.450	$\pm .010$	2.450	—		"	"
1.325	$\pm .010$	1.327	—		"	"
.300	$\pm .010$	.300	—		"	"
.493	$\pm .010$	.495	—		"	"

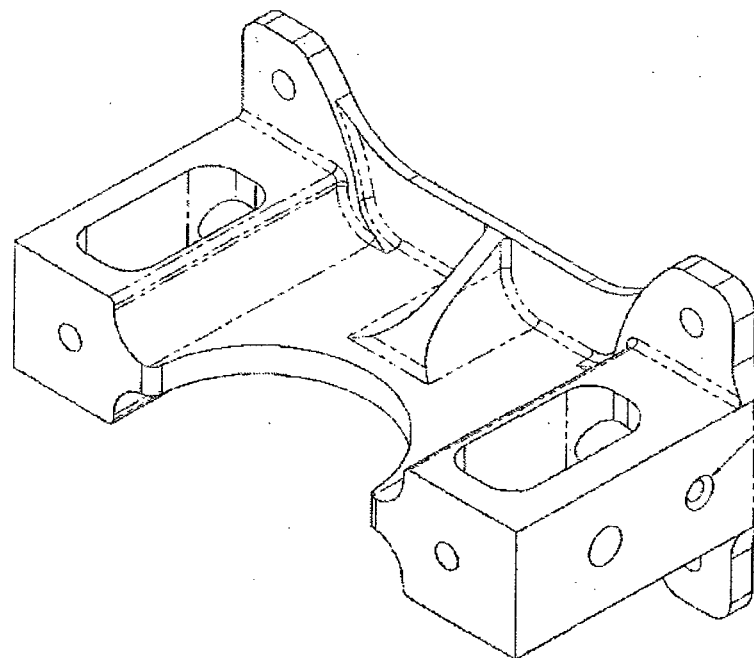
<b>Measured by:</b> <i>aml</i>	<b>Audited by:</b> M.A	<b>Preliminary Approval:</b>
<b>Date:</b> 11/02/15	<b>Date:</b> 11/07/23	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*







MS21209F1-10 HELICAL COIL, 1X  
REF

GRAIN  
DIRECTION

**D4292-1 FITTING**

**RELEASED**  
R 2011-02-01

**NOTES:**

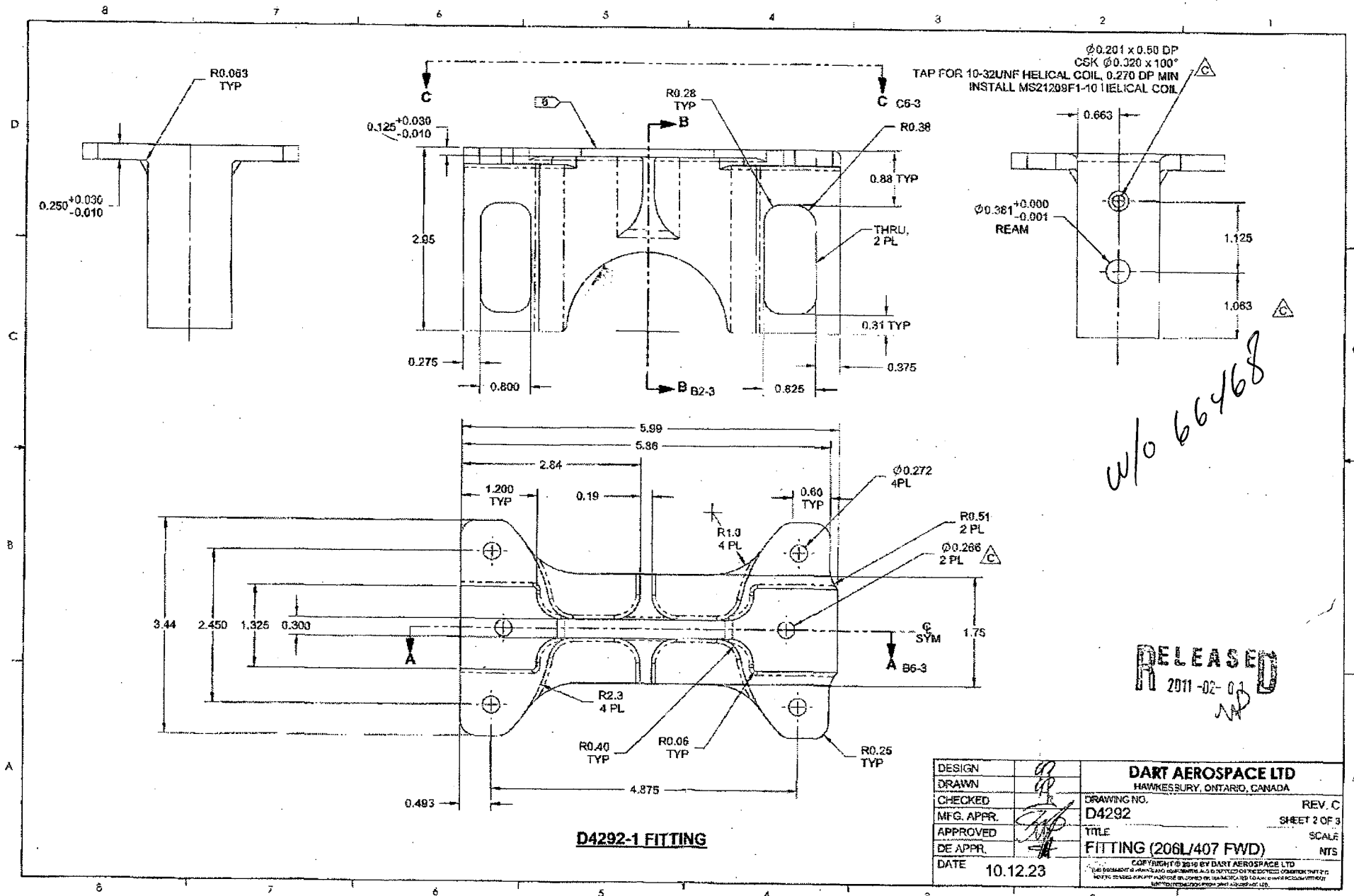
- 1) MATERIAL: 7075-T73/T7351/T73510/T73511 BAR  
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)  
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4292-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.02 lbs

REV.	DESCRIPTION	BY	DATE
C	1.034 WAS 1.235 (C1-2), Ø0.265 WAS Ø0.323 (B3-2), ADD HELICAL COIL (D1-2)	CP	10.12.23
D	0.820 WAS 0.78 (C9-2), 0.825 WAS 0.81 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4292** REV. C  
TITLE **FITTING (206L/407 FWD)** SCALE **NTS**

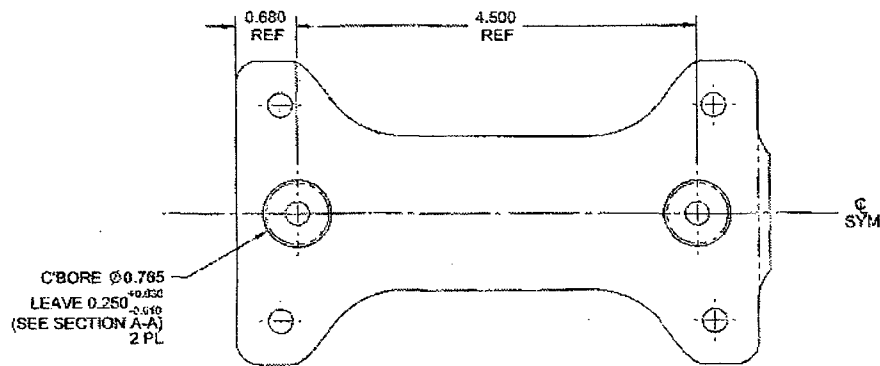
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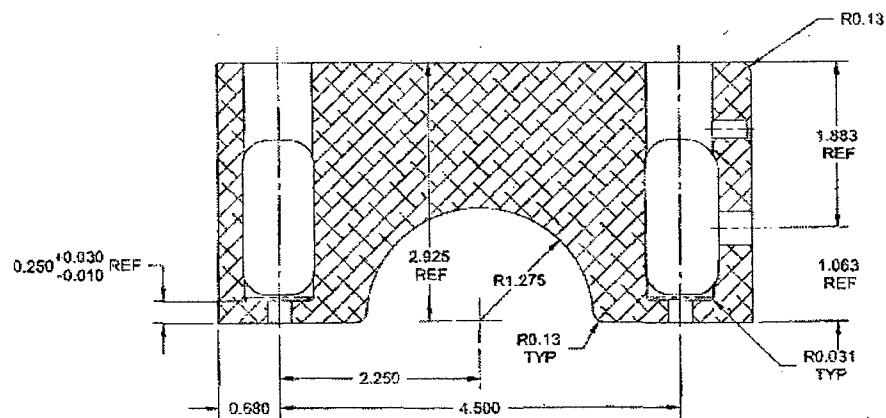
RELEASED  
2011-02-01  
NP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4292	REV. C
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		FITTING (206L/407 FWD)	SCALE
DE APPR.			NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	

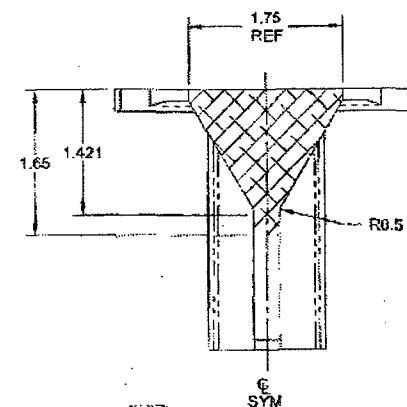
8 7 6 5 4 3 2 1



VIEW C-C D3-2



SECTION A-A A3-2



SECTION B-B C4-2

RELEASED  
2011-02-01  
JMM

DESIGN	DART AEROSPACE LTD	REV. C
DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO. D4292	SHEET 3 OF 3
MFG. APPR.	TITLE	SCALE
APPROVED	FITTING (206L/407 FWD)	NTS
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w/o 66468

8 7 6 5 4 3 2 1